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मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 6844 (1984): Wood and Leather Marking Punches [PGD 6: Earth, Metal And Wood Working Hand Tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”



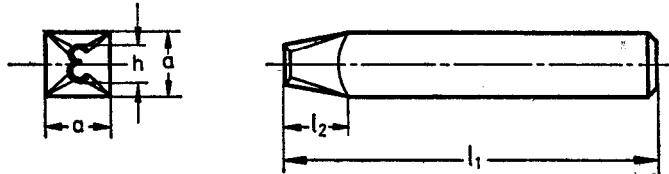
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*Indian Standard*  
**SPECIFICATION FOR  
 WOOD AND LEATHER MARKING PUNCHES**  
*( First Revision )*

1. **Scope** — Lays down the requirements for wood and leather marking punches.
2. **Dimensions**



All dimensions in millimetres.

Letters and Numeral Size <i>h</i>	<i>a</i>	<i>l</i> <sub>1</sub> Approx	<i>l</i> <sub>2</sub> Approx
1·6 2·5 4	7 8 10	70 75 80	1/6 <i>l</i> <sub>1</sub>
6 8 10	12 13 14	85 90 95	
12·5 16 20	16 20 22	100 110 120	

**Note** — For further details about the dimensions of the letters and numerals, reference may be made to IS : 9609-1980 'English lettering for general engineering drawings'.

- 2.1 **Tolerances** — Tolerances on untoleranced dimensions shall be according to the best prevalent manufacturing practices.

### 3. Specimen Letters and Numerals

#### 3.1 Capital Letters



**ABCDEFGHIJKLMNOPQRSTUVWXYZ &**

**Note** — The punch for letter 'l' to be used for marking dash lines, when used horizontally.

#### 3.2 Small Letters



**abcdefghijklmnopqrstuvwxyz**

#### 3.3 Hindu-Arabic Numerals



**012345678**

**Note** — The punch for numeral '6' to be used for marking numeral '9' also.

Adopted 5 March 1984

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Gr 2

# IS : 6844 - 1984

## 3.4 Roman Numerals and Arrows



I II III IV V VI VII VIII IX X →

4. **Material** — Suitable steels meeting the requirements laid down in 5.

*Example:*

45C8 of IS : 1570 (Part 2)-1979 'Schedules for wrought steels : Part 2 Carbon steels (unalloyed steels) (first revision)' with a maximum of 0.05 percent each of sulphur and phosphorus contents.

5. **Hardness** — The hardness of the punch shall be 370 to 400 HV ( $\approx$ 38 to 46 HRC)

6. **Designation** — The wood and leather marking punches shall be designated by the commonly used name, the letter or numeral size and number of the standard:

*Example 1*

A wood and leather marking punch of capital letter 'A' of size 1.6 mm shall be designated as:  
Marking Punch Capital A — 1.6 IS : 6844

*Example 2*

A wood and leather marking capital letter punch set of capital letters of size 1.6 mm shall be designated as:

Marking Punch Set Capital 1.6 IS : 6844

*Example 3*

A wood and leather marking punch of Hindu-Arabic numeral 4 and of 10 mm size shall be designated as:

Marking Punch HA 4 — 10 IS : 6844

*Example 4*

A wood and leather marking punch set of Roman numerals and of 20 mm size shall be designated as:

Marking Punch Set Roman — 20 IS : 6844

7. **Packing** — The wood and leather marking punches shall be supplied in sets in suitable steel cases. The packing shall be in accordance with the best prevalent trade practice.

8. **Marking** — The containers of the punches shall be marked with the nominal size in millimetres, manufacturer's name, initials or recognised trade-mark and the description of the contents. The appropriate letter or numeral as the case may be shall be engraved on one side of the punch so as to facilitate the correct holding of the punch while punching (see figure below).



**Note** — The punch for numeral '6' shall be marked on one side with '6' and on other side with '9' for proper orientation.

**8.1 ISI Certification Marking** — Details available with the Indian Standards Institution.

**9. Sampling** — Unless otherwise agreed to between the buyer and the seller the procedure given in IS : 2500 (Part 1)-1973 'Sampling inspection tables: Part 1 Inspection by attributes and by count of defects, ( *first revision* )' may be followed for sampling inspection. The sampling plan for various characteristics shall be as given in 9.1 and 9.2.

**9.1** For dimensions and specimen of letters and numerals, sampling plan with inspection level III and acceptable quality level (AQL) of 2.5 percent given in Tables 1 and 2 of IS : 2500 (Part 1)-1973 shall be followed.

**9.2** For hardness, sampling plan with inspection level I and acceptable quality level (AQL) of 1.0 percent as given in Tables 1 and 2 of IS : 2500 (Part 1)-1973, shall be followed.

#### EXPLANATORY NOTE

This specification was first issued in 1973.

The current revision has been taken up in order to include the commonly used symbols. It is also in alignment with the latest version of DIN 7354-1978 'Wood and leather marking punches' issued by Deutsches Institute für Normung (DIN).

**AMENDMENT NO. 1 MAY 1996**  
**TO**  
**IS 6844 : 1984 SPECIFICATION FOR WOOD AND**  
**LEATHER MARKING PUNCHES**

*( First Revision )*

*( Page 1, clause 2, Note, line 2 )* — Substitute 'IS 9609 ( Part 1 ) : 1985 Lettering on technical drawings : Part 1 English lettering ( *first revision* )' for 'IS : 9609 - 1980 English lettering for general engineering drawings'.

*( Page 2, clause 4, Example )* — Substitute 'IS 1570 ( Part 2/Sec 1 ) : 1979 Schedules for wrought steels : Part 2 Carbon steels ( unalloyed steels ), Section 1 Wrought products ( other than wire ) with specified chemical composition and related properties ( *first revision* )' for 'IS : 1570 ( Part 2 ) - 1979 Schedules for wrought steels : Part 2 Carbon steels ( unalloyed steels ) ( *first revision* )'.

*( Page 3, clause 9, line 2 )* — Substitute 'IS 2500 ( Part 1 ) : 1992 Sampling inspection procedures : Part 1 Attribute sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection ( *second revision* )' for 'IS : 2500 ( Part 1 ) - 1973 Sampling inspection tables : Part 1 Inspection by attributes and by count of defects ( *first revision* )'.

*( Page 3, clauses 9.1 and 9.2, line 2 )* — Substitute 'Tables I and II-A of IS 2500 ( Part 1 ) : 1992' for 'Tables 1 and 2 of IS : 2500 ( Part 1 )-1973'.

( PE 07 )